

Blzck Smiley

Work Order ID 122814

122814

July-28-14 12:50:34 PM

Page 1

Item ID: D4893-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Hard Point Adapter, LH

Start Date: 7/28/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 8/08/14 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4893

A

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank:3.375" long

2

Ø

NH

14/07/29

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Machine as per Folio FB193 and Dwg D4893

FOLIO REV: AA

DWG REV: A

DEBURR

2

Ø

14/08/21

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122814

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 7/28/14 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 8/08/14 **Req'd Qty:** 2.00 ***~***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

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Item ID: D4893-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Hard Point Adapter, LH
 Start Date: 7/28/14 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 8/08/14 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00				<u>2</u>			DAS 41 9-89 14-8-11
151 *151* Powdercoat Powder Coating	White Gloss (Ref. 4.3.5.1) per OSI005 4.3-Alum 127892 Memo ATTN: BLACK SANDTEX MASK AS PER NOTE 9 S 400 OT 320 F 430	0.00 0.00				<u>2</u>			DAS 41 9-89 14-8-11
155 *155* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>2</u>	<u>2</u>	<u>2</u>	14/08/12

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Page 4

Item ID: D4893-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Hard Point Adapter, LH
 Start Date: 7/28/14 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 8/08/14 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: _____	0.00							
170									
Packaging	Memo	0.00				2x		DAS 28 9-89	AUG 12 2014
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

MLJ 14-08-14

4-8-13

Picklist Print

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Page 1

Work Order ID: 122814

122814

Parent Item: D4893-1

D4893-1

Parent Item Name: Hard Point Adapter, LH

Start Date: 7/28/14

Required Date: 8/08/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 13-05-27 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X05.00 0		Purchased		No			f	3.0750		1			

M6061T6B2 000X05 000

**

6061T6 Bar 2.00 x 5.000

Location

Loc Qty

Loc Code

MAT007

3.075

m128980

3.075



m 126/00

.6

MH 14/07/09

could not pull mat.

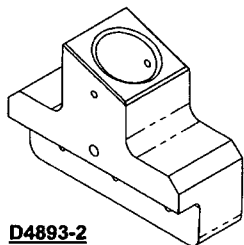
DART AEROSPACE LTD		Work Order: 122814
Description: Hardpoint Adapter, LH		Part Number: D4893-1
Inspection Dwg: D4893	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

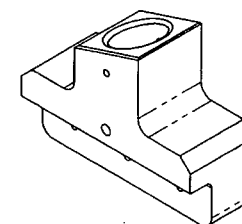
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
72°	+/-0.5°	72°	✓		MIP-01	SQUARE
1.50	+/-0.030	1.503	✓		MIP-04	VERN
0.03 x 45°	+/-0.030 x +/-0.5°	0.030 x 45°	✓	
2.45	+/-0.030	2.450	✓	
1.30	+/-0.030	1.301	✓		31006	Height gauge
0.75	+/-0.030	0.753	✓		MIP-04	VERN
2.500	+/-0.005	2.500	✓	
1.250	+/-0.005	1.250	✓	
R0.25	+/-0.030	0.250	✓		---	Radius gauge
0.50	+/-0.030	0.503	✓		MIP-04	VERN
Ø0.129	+0.005/-0.001	0.129	✓	
Ø0.204	+0.005/-0.001	0.205	✓		↓	↓
1.50	+/-0.030	1.500	✓			
1.00	+/-0.030	1.000	✓			
1.00	+/-0.030	1.000	✓			
R0.13	+/-0.030	0.130	✓		---	Radius gauge
0.83	+/-0.030	0.840	✓		MIP-04	VERN
0.10 x 45°	+/-0.030 x +/-0.5°	0.100 x 45°	✓	
1.75	+/-0.030	1.750	✓	
1.46	+/-0.030	1.465	✓		31006	Height gauge
1.65	+/-0.030	1.648	✓		MIP-04	VERN
4.00	+/-0.030	4.000	✓	
0.25 x 45°	+/-0.030 x +/-0.5°	0.250 x 45°	✓	
0.750	+/-0.010	0.751	✓		31006	Height gauge
Ø1.015	+0.002/-0.001	1.017	✓		MIP-04	VERN

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	DAS 08 9-89	Preliminary Approval:
Date: 14/08/01	Date: 14/08/01		Date:

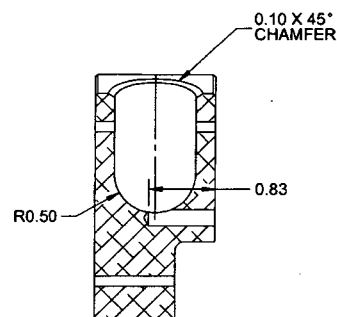
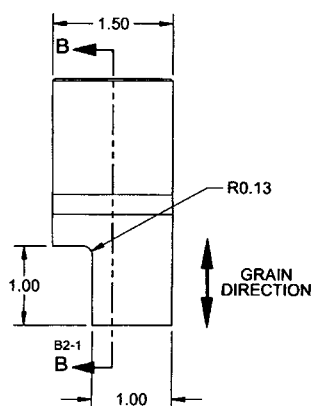
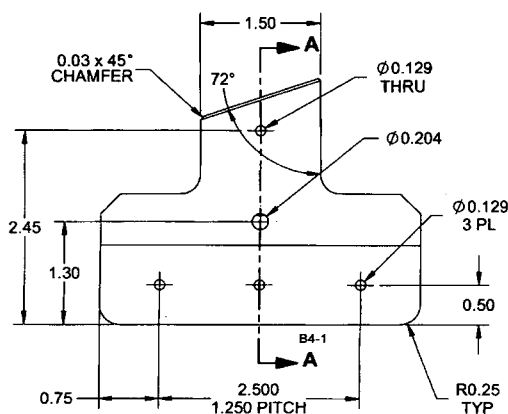
Rev	Date	Change	Revised by	Approved
A	14.07.09	New Issue	KJ	<i>[Signature]</i>



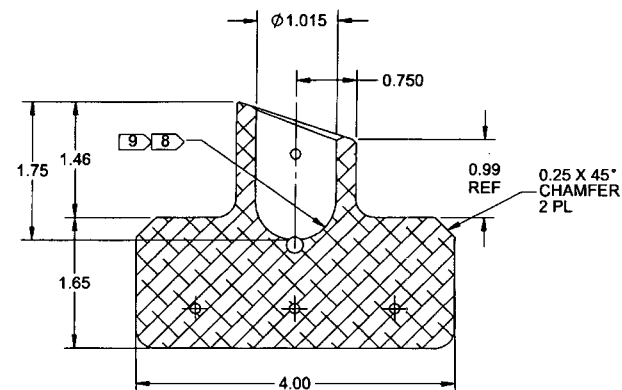
D4893-2



D4893-1



SECTION A-A B7-1



SECTION B-B B6-1

**D4893-1 HARDPOINT ADAPTER, LH
D4893-2 HARDPOINT ADAPTER, RH OPPOSITE**

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.92 lbs
- 8) SURFACE FINISH 80-125 uin. IN THE BOTTOM OF THE Ø1.015 BORE IS ACCEPTABLE
- 9) MASK Ø1.015 BORING HOLE PRIOR TO POWDER COAT

W/0122814

RELEASED
2013-06-12
W/0

A NEW ISSUE		RF 13.05.24	
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. REV. A	
MFG. APPR.	<i>[Signature]</i>	D4893 SHEET 1 OF 1	
APPROVED	<i>[Signature]</i>	TITLE SCALE	
DE APPR.	<i>[Signature]</i>	HARDPOINT ADAPTER NTS	
DATE	13.05.24	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	